· 1 · 9		1) Low							
<b>Work Order ID</b> <i>July 18, 2012 11:21:45</i>		VZND11_	<i>b</i> *871	53*					Page 1
Revision ID:	588-041 or Assembly		Accept	*N9000	4010	ገበ*	Setup Sta	1.7	S1* S2*
Start Date: 7/10/12 Required Date: 8/03/12 Reference:		*1* *1*		Cust Item ID: Customer:					
Approvals: Proce	ess Plan:	Date: 12/07//;		Date			Run Sta	n [7]	R1* R2*
Sequence II3/ Work Center ID Draw Nbr	Operation Description Revision Nbr		Set Up/ Run Hours	Tool ID	Tool # Pla Co		t Reject Qty	Reject Number	Insp. Stamp
D2445/D350-588  100  *100  DC  Document Control	Rev D/D  DOCUMENT CONTR  Memo	OL bluefile and create labels pe	0.00 0.00 0.00 0.00 0.00 0.00 0.00 0.0	S) (3003)			MCI	5 (7	-11-13
110  *110* Purchasing Purchasing	Supplier: I Ship to De	n: D2445 Baggage Door	0.00 0.00 s sheet from Delastek is				Z 12	/07//8	? <u>_</u>

3.

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			DQA	A:Date: .	
NCR: Yes / No	WORK ORDER NON-CO	NFORMANCE / UPI	DATE		
			QA Close	d: Date:	
Work Order:	DISPOSITION		AGAINST DEPARTMEN	IT/PROCESS	
	Rework	Skid-tube	Crosstube	Water Jet	Engineeri
Part No.	Scrap	Machining	Small Fab Pi	rod. Eng. Coor.	Quali
<del></del>	Use-as-is	Thermoforming	Finishing Rec/St	ore/Packaging	Oth

NCR No	·		<u>.</u>	Work Order Update	rder Update Large Fab Composite Supplier						
Root		I		Description of work order update	te l	nitial	Δι	ction	Sign &		1
Cause	Date	Step	Qty	or Non-conformance		ief Eng		cription	Date	Verification	QC Inspector
Doc/Data	Date	эсер	Qty	of Non-comormance	-   -	iei Liigi	Desi	сприоп	Date	vermeation	QC IIISPECTOI
<b>├</b>	-										
Equip/Tooling	-										
Operator	4										
Material	4				·						
Setup	4										
Other	_		] ]			ļ					
Process											
Supplier						]					
Training											
Unapproved											
					FAUL	T CATE	GORY				
Landing	Gear			General				•			
	Bending			Bend		Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to O/	S BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks			Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct –	Weld
	Crushed/	Crimped.		Burrs			ions Incomplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	,		Contamination		Mainte	•		Part Moved	<u> </u>	<b>_</b>
	Heat Trea	ıt		Countersink		Mislabe			Positioned V	Vrong	
<b> </b>	Inspection		Tube	Cut Too Short		Misread			Power Loss/		Other
-	Ripples in	•		Drill Holes		Offset		1			1
-	Torque W		xtrusion	Drawing			Calibration				
·  -	Turning S			Finish		l	equence				
<u> </u>	Wave/Tw			Folio	H	1	Dimensions			<del></del>	
	wave/ IW	ist in Tut	<i>)</i> C			Outside	סוווופוואוטווא				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July 18, 2012 1	1:21:45 AM									
tem ID: Revision ID:	D350-588-0			Accept	*N900	04010	<b>n*</b> s	etup Start Stop	1421	
tem Name:	Aft Door As	sembly						ыор	*NS2*	
Start Date:	7/10/12	Start Qty: 1.00	•		Cust Item	ID:				
Required Date:	8/03/12	Req'd Qty: 1.00	*1*		<b>Customer:</b>					
Reference:							_	<b>a.</b> .		
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:	_ _	un Start	"NR1"	
	QC:		Date:	SPC (Y/N):	<b>D</b>	ate:	_	Stop	*NR2*	
Sequence ID/ Work Center II	D	Operation Description	***************************************	Set Up/ Run Hours	Tool ID	Tool # Plan Code	-		Reject Insp. Number Stamp	
120		Receive & Inspect for	Damage & Mat'l Certs	0.00				//	1	
*120* Packaging		Мето		0.00				-Eti-	4/3/10-(1	-
Packaging		Ensure C	ertificate of Conformity & P	Process Sheet are attached				·		
130		QC6- Inspect dimensi	ons to drawing	0.00	•					
*130*			C	0.00	) 					
QC		Memo		0.00	» Monlis					-
Quality Control			s per Dwg D2445. ocess sheet.							
140				0.00						
*1 <i>4</i> 0*		Small Fab					_//_			)
Small Fab		Memo	D. Cd d	0.00					17	۱.
Small Fab		Assemble	e all of the above parts as pe	r Dwg D330-388			DA 11	S	10-1	1
							-69	in		

12.16.13

										DQA:	Date: _	
NCR: Yes	s / No				WORK ORDER NON-C	ON	FORM	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No.	•				Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No					Work Order Update			Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	ln	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling												
perator		Ì										
Material												
Setup												

Landing	Gear	General					_
	Bending	Bend		Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance		Part Moved	-
	Heat Treat	Countersink		Mislabeled		Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short	Г	Misread	$\Box$	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Г	Offset		•	
	Torque Waves in Extrusion	Drawing		Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			•
	Wave/Twist in Tube	Folio		Outside Dimensions			

**FAULT CATEGORY** 

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Other Process Supplier Training Unapproved

<b>Work Ord</b> July 18, 2012 1				*871	53*							Page 3
Item ID: Revision ID: Item Name:	D350-588-			Accept	*N900	<u>040</u>	100	)*	Setup	Start Stop	*N.	S1* S2*
Start Date: Required Date: Reference:	7/10/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item   Customer:	ID:					IXI	7/
Approvals:		lan:				ate:			Run	Start Stop	1711	₹1* ₹2*
Sequence ID/ Work Center I 150 *150* QC Quality Control	D	Operation Description QC5- Inspect part compl	eteness to step on W/O	Set Up/ Run Hours  0.00 (AS) 16 0.00 9-89	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
*155  *155  Packaging Packaging		Pick Kit <b>Memo</b>		0.00								<u>12/11</u> /14
*160 *160* QC Quality Control		QC4- 100% Inspect kits  Memo	for completeness	0.00	(AS (5) (7) 14							•.

												DQA:	Dat	te:	
NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	COI	NFORM	MANCE / UI	PDATE		·		_	
												QA Closed:	Dat	te:	
Work Ord	ler:					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
Part						Rework Scrap Use-as-is		ļ ,	Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR	No.					Work Order Update		<b>£</b>	Large Fab	Composite		incer stor	Supplier		Julia
Root					Descri	ption of work order update		Initial	А	ction		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Des	cription		Date	Verification	n	QC Inspector
Doc/Data														$\neg$	
Equip/Tooling															
Operator					ĺ										
Material														ŀ	
Setup															
Other														ļ	
Process									-						
Supplier															
Training				Ì											
Unapproved	· .	_										ļ.			•
	;.		•			F.	AUL	T CATE	GORY						
Land	ing (	Gear				General				ų		1			
		Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete	/Unclear		Part Lost/M	issing		Wrong Stock Pulled
		Cuffs	•			Contamination		Mainte	•			Part Moved	l		•
		Heat Trea	at			Countersink		Mislabe	led			Positioned V	Vrong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1			Power Loss/	-		Other

Offset

Out of Calibration

Outside Dimensions

Out of Sequence

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 87153 \*87153\* Page 4 July 18, 2012 11:21:45 AM Item ID: D350-588-041 Accept Setup Start \*N900040100\* **Revision ID:** Aft Door Assembly Item Name: 7/10/12 Start Qty: 1.00 **Start Date: Cust Item ID:** Required Date: 8/03/12 Req'd Qty: 1.00 **Customer:** Reference: Run **Tooling:** Process Plan: Date: **Approvals:** Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Reject Tool ID Tool # Plan Insp. Operation Set Up/ Accept Reject Work Center ID Description Qty Qty Number Stamp **Run Hours** Code 170 Identify as per dwg & Stock Location: 0.00 \*170\* 0.00 Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 180 \*180\* MLJ 12-11-14 0.00 QC Memo

Quality Control

mr 12-11-14 July 18, 2012 11:21:44 AM

Work Order ID:

87153

Parent Item:

D350-588-041

Parent Item Name:

Aft Door Assembly

**Start Date:** 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP P

04.02.04ReformatKJ/DS

CJ/DS IPP Rev:Q as per DSI9414 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2445P AFT DOOR ASSEMBLY		Purchased	No			110	Each	0.0000	1	1	84	53	a
ANS26G832R9 Screw		Purchased	No		(	140	Each	382.0000	8	8/7	1/2	28/9	180
				Location		Loc Qty	<u>Lo</u>	c Code				,	Sy
				ST346	0181	373 21			<del></del>				
				12	1556	152							
	_			12: ST347	2151	200 9			<del></del>				
	2#SUGD	03327			8983	9			~				
W8260JD10	NASH49003631	Purchased	No			140	Each	0.0000	2	(2)	86	m	2297
Washer D2143 Hinge Bracket	211	Manufactured	No			140	Each	29.0000		1 {	<del>7</del> 0.		
				Location		Loc Oty	<u>Lo</u>	c Code			•		
	•			ST 76	100	-28 10							
				ST004	100	19							
				-	335	19				i V	BSI	2F.	10,
DENE Hinge Bracket		Manufactured	No	ST198		140	Each	7.0000	10 22 (388)	1-	384	070	280
				Location		Loc Oty	<u>Lo</u>	c Code			7	\ Ji	ia
				ST005	993	7 7					/ <	ナール	

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	100	NFOR	MANCE / UPDATE		-		
											Q	A Closed:	Date:	
Vork Ord	er:						DISPOSITION			AGAINST	DEPA	ARTMENT/	PROCESS	
Part		•					Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Desc	crir	otion of work order update		nitial	Action		Sign &	<del></del>	
Cause		Date	Step	Qty	000	-	or Non-conformance		ief Eng	Description	ļ	Date	Verification	QC Inspector
oc/Data uip/Tooling perator aterial etup ther rocess upplier raining			1						J				\$	
	<b>.</b>	L		•			F	AUL	T CATE	GORY				
Landi	ng (	Gear	•				General							_
		Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in	Crimped. It n Strip in		o/s		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		1	ion Incomplete ions Incomplete/Unclear enance eled	PPPP	ovalized Over/Under Part Incorrect Part Lost/Mit Part Moved Positioned V	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	$\vdash$	Torque W		xtrusio	n		Drawing	-	1	Calibration	-			
•	$\vdash$	Turning S			'		Finish	-	ł	Sequence	_			

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July 18, 2012 11:21:44 AM

Work Order ID: Parent Item: 87153

D350-588-041

Parent Item Name: A

Aft Door Assembly

Manufactured No

140

479.3174

725

**Start Date: 7/10/12** 

Start Qty: 1.00

Required Qty: 1.00

7.25

Required Date: 8/03/12

D2463 Seal

CAR 57.04

D25%5
Mounting Channel

Manufactured No

ST404 72232 79478

Location

Location ST011

Location

ST203A

Location

ST013

79478 83542

73297

82029

83369 85425

78833 83893 479.31737 15.38

Loc Qty

0.43737 463.5

463.5 Each

72

2

20

Loc Qty

n 72.0000

Loc Code

Loc Code

7.25

B89387 SP

D2586

Manufactured No

(140)

44 Each 100.0000

Each

[2]

2 389150 SP

02620

Manufactured No

100 100 Loc Code

Loc Code

31.0000

27

<sup>2</sup> S\$

Laich Plate, 350 Spacepod

Manufactured No

78991 86368 31 19 12

Loc Qty

Each 28.0000

2x

12-11-13

Hinge Bracket

D2857±0

**Location** ST019

75253 82261 Loc Oty 28

4 24 Loc Code

) V

NCR:	Yes	/ No				WORK ORDER NON-O	CON	<b>NFORM</b>	MANCE / UP	DATE			
											QA Closed:	Date:	<del>.</del>
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-{	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
⊉_ Root			I	I	Doccri	l ption of work order update		nitial	Λς:	tion	Sign &		
E Cause		Date	Step	Qty		or Non-conformance	1	ief Eng		ription	Date	Verification	QC Inspector
Doc/Data	П	Date	Step	Q.,	· ·	or reon comormance		1101 2116		- iption	Dute	Vermedation	QC HISPECTOR
Equip/Tooling	Н												
Operator	П												:
 Material	П									•			
    Setup	П			1.6						•			
Other													
Process											į		
Supplier					;								
Training							Į						
Unapproved				<u> </u>	<u> </u>						<u> </u>		
							AUL	T CATE	GORY				
Landi		1			_	General		1		_	7	<del></del>	1
49	Н	Bending				Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
	$\vdash$	Centre No	ot Concei	ntric to	O/S	BOM/Route	-	Hardwa		<u> </u>	Over/Under	<del></del>	Temperature/Cure
	-	Cracks	<b>6</b>		-	Broken/Damaged	-	1 '	on Incomplete		Part Incorre	<b>├</b>	Weld
	$\vdash$	Crushed/	Crimped	•	-	Burrs	_	4	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
1	$\vdash$	Cuffs Heat Trea			-	Contamination Countersink	$\vdash$	Mainte Mislabe		<u> </u>	Part Moved Positioned V	Mrong	
ľ	-	Inspectio		Tuba	-	Cut Too Short	-	Misread		<u> </u>	Power Loss/	_	Other
i de la companya de l	_	Ripples in	•	rube	<b> </b>	Drill Holes	$\vdash$	Offset	4	· L	Trower ross/	Juige	Totalei
	$\vdash$	Torque M		ytrusia	<sub>n</sub> ⊢	Drawing	-	+	Calibration				
•		Turning S			··	Einish		1	Seguence				

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

July 18, 2012 11:21:44 AM

Work Order ID:	87153						<b>~</b>	D . 7/10/13	D . ID . 0/02/12
Parent Item:	D350-588-041							Date: 7/10/12	Required Date: 8/03/12
Parent Item Name:	Aft Door Assembly						Start	<b>Qty:</b> 1.00	Required Qty: 1.00
02857-2		Manufactured	No		140	Each	16.0000		129150100
linge Bracket									0 (1 344 X F
				Location	Loc Qty		Loc Code		•
				ST019	16				
4C310.431.00		~ · · ·	Ma	78904	140	Each	833.0000		
IS21042L08 ut		Purchased	No		140	Each	833.0000	8	8
ut				Location	Loc Qty		Loc Code		0
				ST300	33		Loc Code		
				121524	33				
				ST317	800				
				122141	800			8	K
1S21042L3		Purchased	No		( 140 )	Each	3,107.0000	2	2 10 030/15 03
Vut									WITH SHOWS ST
				Location	Loc Qty		Loc Code		
				ST300	1107				
				117885	32				
				119017 119075	757 138				
				121444	180				<del></del>
	war.			ST317	2000				
•				122141	2000				
MS27039-1-15		Purchased	No		(140)	Each	31.0000	2	m/33252
crew		:						<u> </u>	77700330
				<b>Location</b>	Loc Qty		Loc Code		8012-11-13.
				ST291	31				
				118574 119736	2				
				121243	1 28				

											DC	)A:_	Date	e: _	
NCR:	Yes	/ No				WORK ORDER NON-	100	NFOR	MANCE / UP	DATE			_		
										···	QA Clos	ed:	Date	e:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTME	NT/	PROCESS		
Part f	No.					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	4		Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR I	NO.	***				Work Order Update	ا ز		Large Fab	Composite	J		Supplier		
Root					Descri	ption of work order update		nitial	Act	tion	Sign 8	ķ.	· <u>.</u>		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desci	ription	Date		Verification	1	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	1														
						F	AUL	T CATE	GORY						
Landi		<b>Bending</b> Centre No	ot Conce	ntric to	o/s	General Bend BOM/Route		Grain Hardwa	are		Ovalized Over/Ur		tolerance		Pressure/Forced Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Inco	orred	ct		Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

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## **Picklist Print**

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Page 4

Work Order ID:	87153									
Parent Item:	D350-588-041				, )		Star	t Date: 7/10/12	Required Date:	8/03/12
Parent Item Name:	Aft Door Assembly						Star	rt Qty: 1.00	Required Qty:	1.00
NAS1149DN832J WASHER		Purchased	No		140	Each	409.0000	8	m 1224	41 SP
				<b>Location</b>	Loc Qty		Loc Code			•
				ST298	409					
				119717	41					
_				120422	368					
N526C1032R7		Purchased	No		155	Each	70.0000	2	2 gb	
SMS				<b>Location</b>	Loc Qty		Loc Code		v	
2/42				ST348	70					
				116304	10					
				119449	60				<del>149</del>	
N526 <u>C832R8</u> crew		Purchased	No		155	Each	127.0000	122	814 JB	
Sha				Location	Loc Qty		Loc Code		. <b>*</b>	-
·		٠		ST346	115					
				120717	15					
				122151	100					
				ST347	12			<del></del>	· · · · · ·	
				116410	3				<del></del>	
				116471	5				Thursday	
				118926	4					
Vasher Sho	NAS1149D0363J	Purchased	No		155	Each	0.0000	2 233	N8 10	8
2150 SA Packer Doubler, Hinge		Manufactured	No		155	Each	36.0000	2 868	83 <sup>2</sup> - 2B	12/11/
_				<b>Location</b>	Loc Qty		Loc Code		/	′ ′ ′
•				ST005	36					C.
				82136	16			-		
				85513	20					

				DQA:	Date:	
NCR:	Yes /	' No	WORK ORDER NON-CONFORMANCE / UPDATE			

												QA Closed:	Dat	e:	
Work Ord	er:					DISPOSITION				AGAII	NST DE	PARTMENT	PROCESS		
Part f	 No					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crossto Small Finish Compo	Fab ning		Water Jet d. Eng. Coor. re/Packaging Supplier	Er	ngineering Quality Other
Root					Descri	ption of work order update		nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	٠,	Date	Verification	ı 📗	QC Inspector
Doc/Data															
Equip/Tooling															
Operator															
Material	Ш														
Setup	Ш														
Other	Ш														
Process	Ш													Ī	
Supplier	Ш														
Training													•		
Unapproved				l			<u> </u>		CODY					i	
1 1:			· ·				AUL	T CATE	GURY				<del></del>		· · · · · · · · · · · · · · · · · · ·
Landi	ng Gea	r nding				General Bend		Grain				Ovalized	1		ssure/Forced
	$\vdash$	_	t Concer	atric to		BOM/Route	-	Hardwa	uro.		$\vdash$	Over/Under	talaranca	<del></del>	nperature/Cure
·	—	acks	Conce	iti ic to	U)3	Broken/Damaged	$\vdash$		ion Incomplete			Part Incorre	,	Wel	•
	$\vdash$		Crimped.		-	Burrs	$\vdash$		ions Incomplete/	/Unclear		Part Lost/Mi	l l	_	ong Stock Pulled
:	Cu		simpea.		<u> </u>	Contamination	$\overline{}$	Mainte		Official		Part Moved	1331118	'````	ong brook r uneu
:	<del></del>	at Trea	t			Countersink	-	Mislabe				Positioned V	Vrong		
			Strip in	Tube		Cut Too Short	_	Misread				Power Loss/	· ·	Oth	ier
	_	oples in			-	Drill Holes		Offset					-		
	То	rque W	aves in E	xtrusio	n	Drawing		Out of	Calibration			<del>111 111 111 111 111 111 111 111 111 11</del>	*		
•	Tu	rning Se	equence			Finish		Out of :	Sequence						
	w.	ave/Twi	ist in Tub	e		Folio		Outside	Dimensions						

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### **Picklist Print**

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Page 5

Work Order ID:	87153											
Parent Item:	D350-588-041							Sta	rt Date: 7/10/12		Required Date: 8	/03/12
Parent Item Name:	Aft Door Assembly							Sta	art <b>Qty:</b> 1.00		Required Qty: 1	.00
D2151 Packer Doubler, Hinge		Manufactured	No			155	Each	40.0000	22	2 .	- g 8 ·	
				Location		Loc Qty		Loc Code				
$\leq_{\mathbb{A}}$				ST005		40						
J# J					82137	20						
					85514	20			85	514		$\sim$
D2153 Door Prop		Manufactured	No			155	Each	52.0000		1	28	
2M 7				Location		Loc Qty		Loc Code			,	•
				ST272		52						
					78369	16						
					85865	36			85	862		
D2154 Stud Bracket		Manufactured	No			155	Each	60.0000		1	95	
- ^				Location		Loc Qty		Loc Code			0	
5W				ST005		60						
					64312	1						
					77024	3						
					82333	56			823	' <i>33</i>		
D2237 Striker Plate		Manufactured	No			155	Each	62.0000	342	925	JB	12/11/14
SKO				Location		Loc Oty		Loc Code			•	A
				ST006		42						
					64426	2						•
					66139	1						
					82062	3						
					83376	36	•					
				ST009		20	)					
					85476	20				-		

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	ATE			
											QA Closed:	Date	:
Work Orde	er.					DISPOSITION		:		AGAINST DE	PARTMENT	PROCESS	
Part N	. No.					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	T	Initial	Acti	on	Sign &		<b>S</b>
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator							1						
Material													
Setup								·					
Other													
Process													
Supplier													
Training	Ш						1						
Unapproved			<u> </u>										
						<u> </u>	AUI	LT CATE	GORY			_	
Landi	ng G	iear				General	_	,		<b></b>	<del></del>	-	_
	Ш	Bending			<u> </u>	Bend	<u> </u>	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
		Centre No	ot Concer	ntric to	O/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	$\vdash$	Cracks				Broken/Damaged		-l `	on incomplete	L	Part Incorre	<b>+</b>	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/M	issing	Wrong Stock Pulled
	Н	Cuffs				Contamination	<u> </u>	Mainte			Part Moved		
	$\vdash$	Heat Trea			_	Countersink		Mislabe		ļ	Positioned V		<del></del>
	$\vdash$	Inspectio		Tube	<u>_</u>	Cut Too Short	L	Misread	i		Power Loss/	Surge	Other
	Ш	Ripples in	Bend			Drill Holes		Offset					
1	1 1	Torque M	Javes in F	extrusion	n I	Drawing	1	Dut of 0	alibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

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Work Order ID:	87153										
Parent Item:	D350-588-041						Star	t Date: 7/10/12		Required Date: 8/0	3/12
Parent Item Name:	Aft Door Assembly						Sta	rt Qty: 1.00		Required Qty: 1.0	0
D2461 Neoprene "D" Seal		Manufactured	No		155	f	684.4367	7.25	7.25		
				Location	Loc Qty		Loc Code			,	
(ut ally 4)	-> measure Sizluly			ST402	184.436684						
P 82 0-4	-> we as our			39782	6.5						
C 0 1-00 V	SISINIA			55054	4						
				63880	14.8237						
Sim	$\mathcal{O}$			73644	159.112984			736	1111		
				ST402A	500			196	44		1
				85225	500						
02589 SWS		Manufactured	No		155	Each	0.0000		1 8	8194	
Keys, Key Chain, 350 H	inge				•			AL J	<u></u> -		
D2690417 Cable		Manufactured	No		155	Each	31.0000		1	- 4	
Simo				Location	Loc Qty		Loc Code				
				ST016	31						
				64786	1						
				66510	1						
				84069	19			858	1.1		
				85866	6			030	<del>\$ 9</del>		
			3.7.	86649	155	E. d.	27.0000				
02858-0		Manufactured	No		155	Each	37.0000	وسال	1	2.8	12/11/13
linge Bracket											<u>1 241<!--1</u-->3</u>
Smy				Location	Loc Qty		Loc Code				
				ST019	37						
				63695	1						
				77019	12			403	21		
				82337	24			823	21		

				DQA	: D	Date:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE				

<del></del>										QA Closed:	Date	:
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap Use-as-is	]       T	f hern	Skid-tube  Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N					Work Order Update	J		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Init	ial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data						1						
Equip/Tooling												
Operator											1	
Material												
Setup	_											
Other			ļ									
Process												
Supplier											:	
Training											į	
Unapproved												
					F	AULT (	CATE	GORY		·		
Landir	ng Gear			_	General					1	_	_
	Bending				Bend		rain		_	Ovalized	<u> </u>	Pressure/Forced
	Centre No	ot Concer	ntric to	o/s	BOM/Route	$\vdash$	rdwa			Over/Under		Temperature/Cure
	Cracks				Broken/Damaged			on Incomplete		Part Incorred	<b>⊢</b>	Weld
	Crushed/	Crimped.		L	Burrs	-		ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	<del></del>		nance		Part Moved		
,	Heat Trea			_	Countersink	$\vdash$	islabe			Positioned V	_	<b>¬</b>
	Inspectio		Tube	ļ	Cut Too Short	<b></b>	isread	i		Power Loss/	Surge	Other
ļ	Ripples ir			<u> </u>	Drill Holes	-	fset			·		
	Torque W			n	Drawing			Calibration				
•	Turning S			<u></u>	Finish	_		Sequence				
	Wave/Tw	ist in Tub	oe		Folio	Ot	utside	Dimensions				

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July 18, 2012 11:21:44 AM

Work Order ID:	87153											
Parent Item:	D350-588-041								Date: 7/10/12		Required Date: 8/03	
Parent Item Name:	Aft Door Assembly							Start	Qty: 1.00		Required Qty: 1.00	0
D2858-2		Manufactured	No			155	Each	32.0000		1	<i>v</i> .	
Hinge Bracket											31	
				Location		Loc Qty		Loc Code			,	
Sm				ST019		32						
<u> </u>				64	787	I						
				77	020	8						
				82	336	23			\$23	36		<b>.</b>
FG-97815045504ROL 7781 9oz Glass 50"x125	yd	Purchased	No			155	sf	2,764.4910	123	239	Jb	
**				Location		Loc Oty		Loc Code			V	
				CA		2764.491						
2 per	7				4845	3						
\(\frac{1}{2}\)					18932	18						
				11	1166	392						
					3905	564						
					7602	664.651						
				11	9099	1122.84						
M\$20426AD3±4) RIVET		Purchased	No			155	Each	2,552.0000	1230	21	JB_	
				Location		Loc Oty		Loc Code			U	
S.M.				ST316		2552						
				10	4374	236						
				11	0398	2316			-			
MS20470AD445) Rivet, Universal Head		Purchased	No			155	Each	1,136.0000	1224	چ <sup>18</sup>	- 93	12/11/1
510				Location		Loc Qty		Loc Code				
She				ST319		1136						
					8405	3 <b>8</b> 9						•
					20142	747			<del></del>			

											DQA:	Date	::
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORI	MANCE / UPDATE				
						_					QA Closed:	Date	): 
Work Ord	or.					DISPOSITION			AGAIN	ST DE	PARTMENT	PROCESS	
Part I	- _ No					Rework Scrap Use-as-is		1	Skid-tube Crosstu  Machining Small F  noforming Finishi	ab		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	NO					Work Order Update	j		Large Fab Compos	ite[		Supplier	
Root					Descri	ption of work order update	Π	Initial	Action		Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data				ł									
Equip/Tooling													
Operator							1					:	
Material													
Setup													
Other											!		ļ
Process	Ш				į								
Supplier													
Training	Ш												
Unapproved	Ш												
						<u> </u>	AUI	LT CATE	GORY				
Landi						General	_	1		_	<b>-</b> 1	F	
	$\vdash$	Bending				Bend	_	Grain		<u> </u>	Ovalized	1	Pressure/Forced
1	$\boldsymbol{\vdash}$	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa		$\perp$	Over/Under	<u> </u>	Temperature/Cure
	-	Cracks				Broken/Damaged		-l `	on Incomplete		Part Incorre	<b>⊢</b>	Weld
	∐'	Crushed/	Crimped,			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	issing	Wrong Stock Pulled
	∐'	Cuffs				Contamination		Mainte	enance		Part Moved		
[		Heat Trea	it			Countersink		Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

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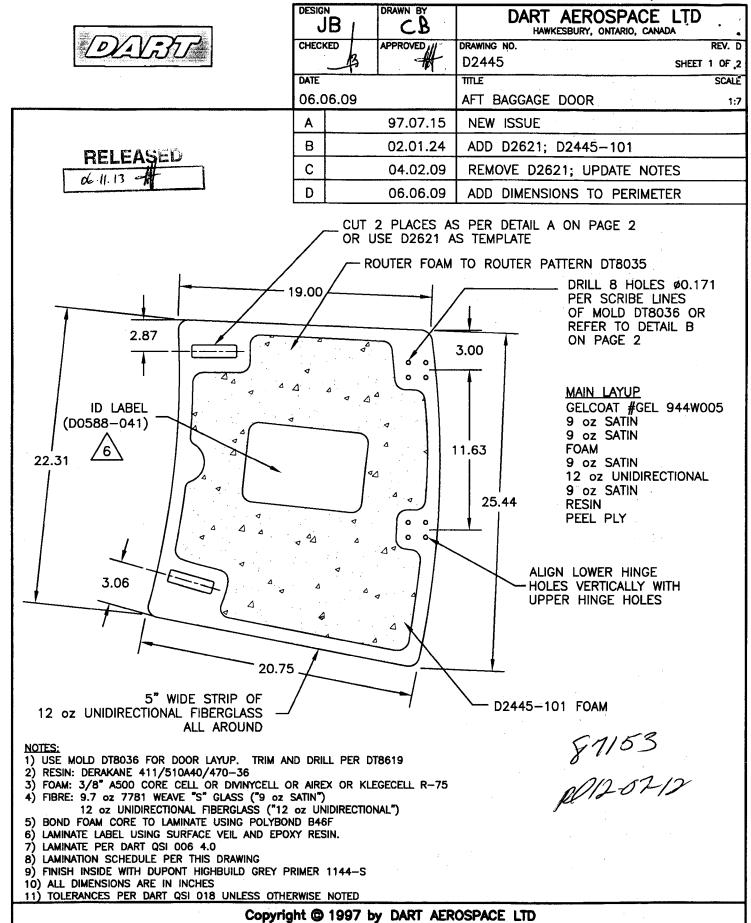
ork Order ID:	87153									
arent Item:	D350-588-041							Date: 7/10/12		ired Date: 8/03/12
arent Item Name:	Aft Door Assembly						Start	Qty: 1.00	Req	uired Qty: 1.06
S21042L08	·	Purchased	No		155	Each	833.0000	10	10	
				<b>Location</b>	Loc Oty		Loc Code			•
Smo				ST300	33					
				121524	33					
	***			ST317	800				<del></del> ,	
	• .			122141	800			122/	<del>4</del> 1	_
2101513		Purchased	No		155	Each	3,107.0000	4	4/23	3265
				Location	Loc Qty		Loc Code			4
$\mathcal{H}$				ST300	1107			-		
. ,				117885	32					
				119017						
				119075					<u> </u>	
				121444				-		
				ST317	2000					
				122141	2000					1
27039408401 sw		Purchased	No		155	Each	59.0000	27	2 —	
5W>				<b>Location</b>	Loc Qty		Loc Code			
3r /				ST290	7					
				117441	7					
				ST292	52					
				116289	2					
				120833	50			1208	<u>35</u>	
S1149DN8320 SHER		Purchased	No		155	Each	409.0000	1224	141	12/11/13
				Location	Loc Qty		Loc Code		V	
5mB				ST298	409					
				11971						, <b>**</b>
				120422						·
				120422	. 500					

											DQA:	Date:		
NCR: Y	'es	/ No				WORK ORDER NON-C	ONFO	RIV	IANCE / UP		QA Closed:	Date:		
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No.				Scrap Machining Small Fab			Crosstube Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other				
NCR N	lo				Work Order Update Large Fab Composite				,	Supplier				
Root					Descri	ption of work order update	Initia	nitial Action		Sign &		·		
Cause		Date	Step	Qty	C	or Non-conformance	Chief E	ng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data														
Equip/Tooling		·												
Operator				ļ				į						
Material														
Setup														
Other														
Process														
Supplier			1					- 1						
Training														
Unapproved			[											

#### **Landing Gear** General Grain Pressure/Forced Bending Bend Ovalized Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Broken/Damaged Weld Cracks Inspection Incomplete Part Incorrect Instructions Incomplete/Unclear Wrong Stock Pulled Crushed/Crimped. Burrs Part Lost/Missing Cuffs Maintenance Part Moved Contamination Mislabeled Positioned Wrong Heat Treat Countersink Misread Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes Offset Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Turning Sequence Finish Folio Outside Dimensions Wave/Twist in Tube

**FAULT CATEGORY** 

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											DQA:	Date:		
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE					
	_										QA Closed:	Date:	1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 -	
Work Ord	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No				Rework Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Work Order Update Large Fab Composite			!	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other					
Root					Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
							AUL	T CATE	GORY					
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection	Crimped. at n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		4 '	on Incomplete ions Incomplete/Unclear nance led		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \ Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

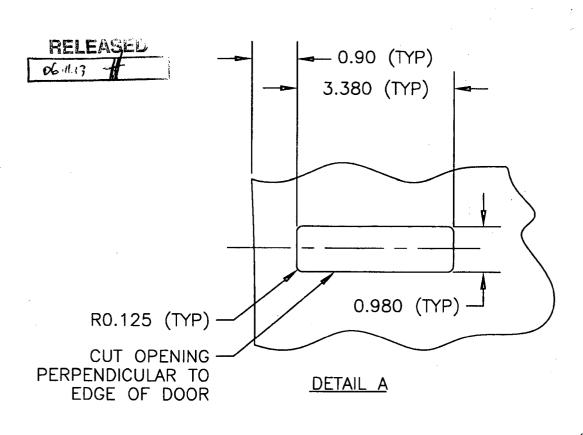
Drawing

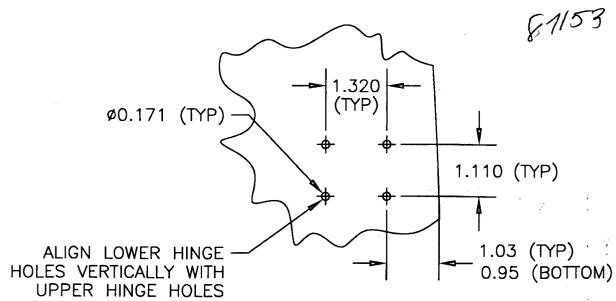
Finish

Folio



JB	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED /2	APPROVED //	DRAWING NO.	REV. D
_ P	THE THE	D2445	SHEET 2 OF 2
DATE		TITLE	SCALE
06.06.09		AFT BAGGAGE DOOR	1:2





**DETAIL B** 

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										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CON	IFORN	MANCE / UPDATE		QA Closed:	Date:	
Work Orde	er:				DISPOSITION AGAINST D			DEI	DEPARTMENT/PROCESS			
Part No			Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing			Prod. Eng. Co Rec/Store/Packag			Engineering Quality Other		
Post		[	<u> </u>	Doscri	ption of work order update	1	nitial	Action		Sign &		[
Root Cause	Date	Step	Qty	i '	or Non-conformance	1	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data	- Dute	Jeep	αι,		or more companied			5550, p. 10.				
Equip/Tooling												
Operator							,	·	ļ			
Material												
Setup												
Other							•					
Process												
Supplier												
Training												į
Unapproved												
					F	AUL'	T CATE	GORY				
Landi	ng Gear				General	_		,	_		r—	7
	Bending				Bend	Ш	Grain			Ovalized		Pressure/Forced
Centre Not Concentric to O/S			BOM/Route	Ш	Hardwa	re	<b></b>	Over/Under		Temperature/Cure		
	Cracks			<u> </u>	Broken/Damaged	-		ion Incomplete	<u> </u>	Part Incorred	<del>}</del> -	Weld
	Crushed/	Crimped.			Burrs	-		ions Incomplete/Unclear	—	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs			ļ	Contamination	Ш	Maintenance			Part Moved		
	Heat Treat			Countersink		Mislabeled			Positioned V	Vrong	_	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



DELASTEK Inc. 2699 5e Avenue Local 14, C.P. 10100 Grand-Mère, Québec G9T 5K7

Canada Tel.: (819) 533-5788

Fax: (819) 533-3494

# PACKING SLIP

#### CERTIFICATE OF COMPLIANCE

Invoice No.	44870.
Customer No.	DART US

	1-97	~ pr	Bill	TA			 	
	 	a deministra		I U				

DART AEROSPACE LTD 1270, Aberdeen Street Hawksbury, Ontario K6A 1K7 Canada

Telephone: 613-632-5200 Contact: Linda Lacelle Ship To

DART AEROSPACE LTD 1270, Aberdeen Street Hawksbury, Ontario K6A 1K7 Canada

Telephone: 613-632-5200 Contact: Linda Lacelle

Accepted by

Quality department

AQ-357

Ship Date Order Date Our SO# Ordered by Your PO# Terms 07-09-2012 18-07-2012 21354 Chantal Lavoie PO17478 Net 30 days USA Ship Via F.O.B. GST/PST Salesperson FEDEX P1 Collect Point de départ Claude Lessard, ext. 233 B.O. Current Order Item number Description Ship. Qty Qty 1 0 DKC134-0013 Line 2 D350-588-041 Aft Baggage Door (D2445) U of M: Chaque B87153 Drawing No: D2445 Rév.: D Serial # No. Lot B87153. 43209 WB #7989-1735-8620 17/09/11 SHIP 07 SEP. 2007 (39) 798 9-1735-8620V FED-PIV pluning in cho

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Cust.

 $\prod$  Adm.

☐ Quality

(4 Ship.

#### DELASTEK AERONAUTIQUE



Mardi, 2012-07-24 09:04:48 Date:

Utilisateur: marc dubé

Feuille de Procédé

Client Numéro Job Numéro

: DART US DART AEROSPACE : 43209

: 3959

Numéro B.A.

Cette fois : 2012-07-24

Prsht Rev. ; NC

Prem. fois : 39934 Job précédente

Ècrit par

Vérifié & Approuvé par

Commentaires : N° de pièce Client: D2445

AAC1887 était AC0884, , # de projet était DK-134.

Nom Dessin : N° D2445, AFT BAĞGAGE DOOR Numéro Article : DKC134-0013

Numéro Dessin : D2445 Projet Numéro : DK-362

Révision dessin : D Matériel

Date Dûe

: Composite : 2012-09-05

Qté: 1 Ud UNITE

B87153 Process Sheet Rev.: 02 AAC1885 était AC0883,

Produit additionnel

Numéro Job:



Type

# Séq.:

Machine ou

Description:

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Qty.: 0.200 UNITE(s)/Unit Total

N° 83634, Frekote Loctite Wolo

0.200 UNITE(s)

PREP-GENERAL

Préparation du matériel

Comment

2.0

Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation du moule N° DT-8026 selon IG 0009.

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Comment

Qty.:

AMB0286

0.200 KILOGRAMME(s)/Unit

Gel Coat Blanc N° Gel 944W005

Comment

Comment

Qty.: 0.0320 GALLON(s)/Unit Total

N° de Lot:

Catalyst N° DDM-9

5.0

4.0

PREP-GENERAL



Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantitées requises, mix ratio 1.5% catalyst par quantité de résine



Date:

Mardi, 2012-07-24 09:04:48

Utilisateur:

marc dubé

DART US DART AEROSPACE

Feuille de Procédé

Client:

Nom Dessin:

N° D2445, AFT BAGGAGE DOOR

Numéro Job: Numéro Job:

43209

# Séq.:

Machine ou Opération:

Description:

DKC134-0013

Numéro

6,0

GEL COAT

Application du Gel Coat







Comment

Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire l'application du Gelcoat selon 1G 0019



7.0

Qty.:

Tissu à délaminer Release ply B

Comment

Comment

1.52 VERGE(s)/Unit Total: Tissu à délaminer Release ply B

1.52 VERGE(s)

# de Lot:

Feutre de drainage

8,0

AAC1887 Qty.:

Wrightlon 5200 Bleu F

3.33 VERGE(s)/Unit Total:

Wrightlon 5200 Bleu P3

2.00 PIED(s)/Unit

3.33 VERGE(s)

AC0885 9.0

Comment Qtv.:

2.78 VERGE(s)/Unit Total: 2.78 VERGE(s)

Total:

AC0943

Stretchlon 200 poche à vide Vert

10,0

2.00 PIED(s)

Comment 11.0 AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment

Comment

Qty.:

Qty.:

2.0 VERGE(s)/Unit Total:

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

2.0 VERGE(s)

12.0

AMB0349

Fiberglass 12 oz Unidirectional

Qty.: 0.33 VERGE(s)/Unit

0.33 VERGE(s)

Fiberglass 12 oz Unidirectional. AC0886

11º de Lot: 1. 22549-/

Ruban à gommer jaune #: T/AT-200Y

13.0

Qty.:

Total: 1.2500 ROULEAU(s)

Comment

14.0

1.2500 ROULEAU(s)/Unit

Préparation du matériel







Comment

Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Tailler le matériel, selon les différents paterns de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

- 3 fois le sac à vide Strechlon 200.
- 3 fois le film perforé P-3
- 3 fois le feutre de drainage
- 2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).

Appliquer le ruban jaune tout le tour du strechlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Date:

Mardi, 2012-07-24 09:04:48

"Utilisateur:

marc dubé

Feuille de Procédé

Client:

DART US DART AEROSPACE

43209

Nom Dessin: N° D2445, AFT BAGGAGE DOOR Numéro DKC134-0013

Numéro Job:

Numéro Job:



# Séq.:

Machine ou Opération:

Description:

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en

les superposant les uns sur les autres.

oceau:

15.0

Catalyst N° DDM-9

Comment

Qty.:

0.0130 GALLON(s)/Unit Total, Catalyst N° DDM-9

N° de Lot:

16.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment

Qty.:

0.360 KILOGRAMME(s)/Unit Total: Résine (411B7530) 411-350 promo. 75min.

0.360 KILOGRAMMEL

N° de Lot:

17.0



Préparation du matérie



Comment

Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 1.5% de catalyst N°

DDM-9 par quantité de résine N° 411-350,

18.0

Faire le laminage



Comment

Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un pfis de tissu 9.7 oz.

Recommencer l'opéaration pour le deuxième pli.



19.0

Faire le bagging sur la pièce



Comment

0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la poche à vide selon 1G 0012.

Laisser sécher pendant 4 heures minimum.



DateX

Date: Mardi, 2012-07-24 09:04:48 Utilisateur: marc dubé Feuille de Procédé Client: DART US DART AEROSPACE Nom Dessin: N° D2445, AFT BAGGAGE DOOR 43209 Numéro Job: Numéro DKC134-0013 Numéro Job: # Séq.: Machine ou Opération: Description : 20.0 AMB0286 Catalyst N° DDM-9 Comment Qty.: 0.0042 GALLON(s)/Unit Total: 0.0042 GALLON(s) N° de Lot: 1-27929-Catalyst N° DDM-9 AMB0212 21.0 Résine (41187530) 411-350 promo. 75min. Comment Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: / -22.0 Préparation du matériel Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core selon IG0105. Date: 17-11-15 Sceau: 23.0 AAC1611 Polybond B46F Comment Qty.: 0.045 KIT(s)/Unit Total: Polybond B46F N° de Lot: 24.0 DKC134-0029 Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) Foam Core N° D2445-101 ( Pour AFT Baggage Door ) 25.0 Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Assembler in DKC134-0029 selon IG 0033 26.0 Faire le bagging sur la pièce Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire la poche à vide selon IG 0012 Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond. Heure Fin Curing:

Date:

Mardl, 2012-07-24 09:04:48

Utilisateur:

marc dubé

Feuille de Procédé

Client:

DART US DART AEROSPACE

N° D2445, AFT BAGGAGE DOOR

Numéro Job:

43209

Numéro DKC134-0013

Numéro Job:

# Séq.:

Machine ou Opération:

Description:

27.0

28.0

AMB0286

Catalyst N° DDM-9

Comment

Qty.: 0.1360 GALLON(s)/Unit Total: Catalyst N° DDM-9 N° de Lot.

AMB0212

Comment

Résine (411B7530) 411-350 promo. 75min.

Qty.: 0.360 KILOGRAMME(s)/Unit Total: Résine (411B7530) 411-350 promo. 75min.

0.360 KILOGRAMME(s N° de Lot:

29.0

PREP-GENERAL





Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst

N° DDM-9 par quantité de résine N° 451-350.





Faire le laminage

30.0





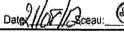
Comment

0.00Hrs/ Run: 0.0000Min Total dun: 0.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz





310

Comment

Faire le bagging sur la pièce



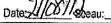
Setup: 0.00Hrs/ Run: 0.0000Min | Total Run: 0.0000Hrs



Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Heure Curing Fin: 8.00





Date:

Mardi, 2012-07-24 09:04:48

Utilisateur:

marc dubé

Feuille de Procédé



Client: Numéro Job:

43209

DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro

DKC134-0013

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

32.0

DÊMOULAGE

Démoulage de la pièce

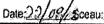




Comment

Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Démouler la pièce en faisant bien attention aux coins & Edges.



33.0

Trimage

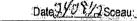




Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de pent de sein N° D2445.



34.0

Label N° D0588-041

Comment

1 UNITE(s)/Unit

Qty.: Label N° D0588-041

Total: N° de Lot:

AAC1609 35.0

Comment Qty.:

0.07 VERGE(s)/Unit Surface Veil N° de Lot 0.07 VERGE(s)

36.0

AAC1220

Résine Mia-Poxy 100

0.007 GALLON(s)/Unit Total: Qty.: N° de Lot:

0.007 GALLON(s)

37.0 AAC1221

Qty.:

Résine Mia-Poxy 100

0.007 QUART(s)/Unit Total: Durcisseur 95 Pour Résine Mia-Poxy

0.007 QUART(s)

38.0

ASSEMBLAGE



Comment

Coller le label N° D0588-041 selon IG 0111.



	Mardi, 2012-07-2 marc dubé	24 09:04:48	Feu	ille de Procédé	
Clier Numéro Job		DART AEROSPACE		Nom Dessin: Numéro	N° D2445, AFT BAGGAGE DOOR DKC134-0013
Numéro Job:			***************************************	and the second s	
# Séq.:	Machine o	u Opération:		Des	cription 5
39.0	AAC1492			N° P-15-3, Adtech Micro Ultra	Filler
Comr	N° P-15	0.014 GALLON(s)/Ut -3, Adtech Micro Ultra		0.014 GALLON(s) # de Lot: 1 ~ 36	797-/
40.0	FINITION			Finition Générale	(11111111111111111111111111111111111111
Comn	nent Setup: 0	.00Hrs/ Run: 0.0000N	in Total Run	: 0.0000Hrs	
	Faire les	réperations de finitio	n sill y a lieu à	l'aide du "Filler" P15-3.	
41.0	Date: _/_	ICI/Icaceau:	30 7		
Comm	AAC1021 nent Qty.; (	0.0280 UNITE(s)/Unit	t Total: 0	Dupont Primer N° 7704S  0.0280 UNITE(s)	
	Dupont F	rimer N° 7704S	N° de Lot:_	1-34195-2	in.
42.0 Comm	AAC1101	0000 (0000)		N° 7775S, Dupont Activator - F	Reducer Chromabase
Comm		).0283 UNITE(s)/Unit 5, Dupont Activator - I		0.0283 UNITE(s) mabase N° de Lot	1-34636-5
43.0	PRIMER	191 PF 4874 1888 3	<del></del>	Application primer	
Comm	ent Setup: 0.0	0.0000M	in Total Run	: 0.0000Hrs	DOPMER DRIMER
	Faire la n	réparation et l'applica	ilion du nrimer	selon 1.G. NOOR	premier primer:
	1	oparation of rapping		1)	LOT ACTIVATOR:
44.0	Date: \_\ INSPEC_FINA	Sceau:	www.marinianyte.com	de fiche de mélange: 1/15 Inspection finale	A 57 1-33616-2
Comme	Millimited		- T. J. J. D	0.00001	
Commit	site Setup. U.C	0Hrs/ Run: 0.0000Mi	n rotal Run :	0.0000Hrs	•
	Faire l'insp	pection selon le dessi	n N° D2445.		
	Date (e.S.	pt Li Sceau:	<u> </u>		
45.0	EMBAL / ENTF	REPO	Ε	Emballage & Entreposage	A ARRIVA AMPLY OFFICE (MAIL 1884)
Comme	nt Setup: 0.0	0Hrs/ Run: 0.0000Mii	n Total Run :	0.0000Hrs	
	Faire l'emb	allage des pièces se	Jop JG 0057		
	Date:	e	(53)		•
	Dale. 1	Sceau!			

ICA-D350-588

ICA Page 33 (34 blank) of 34

#### **52.3 WEIGHT AND BALANCE**

Installation	Weight	LAT	ERAL	LONGITUDINAL		
		Arm	Moment	Arm	Moment	
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb	
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg	
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb	
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg	

<sup>\*</sup> D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

#### **52.4 PARTS LISTS**

Revision: 0

5044/-		Part Number	Description
\$588 \$0412	-011		
てxノ		D350-588-041	AFT DOOR ASSEMBLY
	Χ	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
<b>C</b> 22	2	D2150	HINGE PACKER
<b>~2</b> 5	2	D2151	HINGE DOUBLER
<b>13</b> D	1	D2153-3315-10	GAS SPRING ASSY.
(1)	1	D2154	STUD BRACKET
(-2)	2	D2237	STRIKER PLATE
21		D2445	DOOR
~1	1	D2461-0870	NEOPRENE D SEAL
21.5	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
<u></u>	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
<b>U</b> <sub>2</sub>	1	D2589	KEYS, KEY CHAIN
<del>2&gt;</del>		D2621	LATCH PLATE
70	1	D2690-17	CABLE, DOOR STOP
EP	1	D2857-1	LOWER HINGE BRACKET
<b>=</b>	1	D2857-2	UPPER HINGE BRACKET
<b>V</b>	1	D2858-1	LOWER HINGE BRACKET
2-1	1	D2858-2	UPPER HINGE BRACKET
<b>C</b> 855	8	AN526C832R8	SCREW (or AN526-832R8)
<b>८</b> 8⊐	8	AN526C832R9	SCREW (or AN526-832R9)
2ء	2	AN526C1032R7	SCREW (or AN526-1032R7)
(24)	24	AN960JD8	WASHER -/6
<b>¢</b> 4⊃	4	AN960JD10	WASHER
420	12	MS20426AD3-4	RIVET
7483	18	MS20470AD4-5	RIVET
	18	MS21042L08	NUT (or MS21042-08) — /∂
4.3	4	MS21042L3	NUT (or MS21042-3)
_2	2	MS27039-1-15	SCREW
2-	2	MS27039-0811	SCREW
_4_	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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